



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6205G00632-3G

Job Sheet 186402



Part No: RBW6205G00632-3G

Job Qty: 1 pcs

Part Name: Sling, Main Rotor Blade Lift



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/15/18

Job Tracking No:

Due Date: 4/4/19 *4/25/2019*

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RBW6205G00632-3G Rev 6 IPP Rev A 18.01.11 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	1 pcs	<i>DP</i>	4/4/19	0.00	0.00	Purchasing - 1		<i>DP</i> APR 25 2019
							Purchasing - 2		
							Purchasing - 3		
110	Packaging 2-1 - Receive - B4B	1 pcs		4/4/19	0.00	0.00	Packaging 2 - 1 - B4B		<i>DP</i> APR 25 2019
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 - B4B		
							Packaging 2 - 21 - B4B		
							Packaging 2 - 22 - B4B		
							Packaging 2 - 23 - B4B		
							Packaging 2 - 24 - B4B		
							Packaging 2 - 25 - B4B		
							Packaging 2 - 26 - B4B		
							Packaging 2 - 27 - B4B		
							Packaging 2 - 28 - B4B		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S175211



Part: RBW6205G00632-3G

Job No: 186402

Serial No/Batch: S175211

Revision: 6

Inspector:

Exp Date:

Instructions:

Date: 04/25/19

					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
120	QC 6	1 pcs	4/4/19	0.00 0.00	QC 6 - 9	AUG 27 2019
					QC 6 - 68	
					QC 6 - 61	
121	Small Fab - 2 - B4B	1 pcs	4/4/19	0.00 2.00	Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	MLL
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
122	QC 5	1 pcs	4/4/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
130	Packaging 3-1 - Stock - B4B	1 pcs	4/4/19	0.00 0.00	Packaging 3 - 1 - B4B	AUG 27 2019
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	

DAS
40
9-89

MLL

AUG 27 2019
DAS
40
9-89

DAS
28
9-89

GA-F/100

				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - FG	1 pcs	4/4/19	0.00 0.00	QC 21 - FG - 21	21
				QC 21 - FG - 70	70
				QC 21 - FG - 53	53

Part Op 100 - Issue P/O: _____ MANUFACTURE RBW6205G00632-3G AS PER DWG Supplier: METEC Certificate of
 Descriptions: conformity is required
 110 - (Receive & Inspect for Damage & Mat'l Certs
 120 - (QC6- All purchased or subcontracted products)
 121 - PERFORM FIRST ARTICLE WEIGHT TEST 1. AFTER INSPECTION, PLACE 300 LBS. IN M/R BLADE LIFTING TOOL. LIFT M/R BLADE LIFTING TOOL USING AN APPROPRIATE LIFTING DEVICE, FOR AT LEAST 5 MINUTES, CONTINUALLY CHECKING FOR CRACKS, DEFLECTION, OR DISTORTION. 2- REMOVE WEIGHT AND RE-INSPECT TOOL, CHECKING FOR STRESS CRACKS, BENDING, OR DISTORTIONS. Fill out inspection sheet. (sheet 47). 3- Engrave RB41011 placard. 4-Transfer drill placard as per DWG. 5-Using #2 drive screws install placard 6-Apply sticker as per DWG.
 122 - (QC5- Inspect part completeness to step on W/O)
 130 - (Identify as per dwg & Stock Location: _____)
 140 - (QC21- Final Inspection - Work Order Release)

GA-Floor
AUG 28 2019

PO Details				
Metec Metal Technology Inc. (mem001-vc)				
				
PO No: PO041736				
Line No: 4				

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
61 RBW6205G00632-3GP	Sling, Main Rotor Blade Lift	1 pcs (1 ea)	100-Purchasing	5175210
90081A074	0.125 X 0.500 #2 Drive Screw	4 Ea (4 ea)	121-Small Fab - 2 - B4B	5122133
82 RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	121-Small Fab - 2 - B4B	5021040
RBW6205G00632-3G-77	Sticker	1 pcs (1 ea)	121-Small Fab - 2 - B4B	5142773

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBW6205G00632-3GP	1	0	0
121-Small Fab - 2 - B4B	90081A074	4	139	0
	RB41011	1	366	0
	RBW6205G00632-3G-77	1	5	0

Part Specifications	
Specifications could not be found.	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6205G00632-3G
Job Sheet 186402



Part No: RBW6205G00632-3G

Job Qty: 1 ea

Part Name: Sling, Main Rotor Blade Lift



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/15/18

Job Tracking No:

Due Date: 2/7/19 04/14/2019

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RBW6205G00632-3G Rev 6 IPP Rev A 18.01.11 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	1 pcs		2/7/19	0.00	0.00	Purchasing		
110	Packaging	1 pcs		2/7/19	0.00	0.00	Packaging2		
120	QC	1 pcs		2/7/19	0.00	0.00	QC6		
121	Small Fab	1 pcs		2/7/19	0.00	2.00	Small Fab-5		
122	QC	1 pcs		2/7/19	0.00	0.00	QC5		
130	Packaging	1 pcs		2/7/19	0.00	0.00	Packaging3		
140	QC21-FG	1 Ea		2/7/19	0.00	0.00	QC21		

Part Op 100 - Issue P/O: _____ MANUFACTURE RBW6205G00632-3G AS PER DWG Supplier: METEC Certificate of Descriptions: conformity is required

121 - PERFORM FIRST ARTICLE WEIGHT TEST 1. AFTER INSPECTION, PLACE 300 LBS. IN M/R BLADE LIFTING TOOL. LIFT M/R BLADE LIFTING TOOL USING AN APPROPRIATE LIFTING DEVICE, FOR AT LEAST 5 MINUTES, CONTINUALLY CHECKING FOR CRACKS, DEFLECTION, OR DISTORTION. 2- REMOVE WEIGHT AND RE-INSPECT TOOL, CHECKING FOR STRESS CRACKS, BENDING, OR DISTORTIONS. Fill out inspection sheet. (sheet 47). 3- Engrave RB41011 placard. 4- Transfer drill placard as per DWG. 5- Using #2 drive screws install placard 6- Apply sticker as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW6205G00632-3GP	Sling, Main Rotor Blade Lift	1 pcs (1 ea)	100-Purchasing	
90081A074	0.125 X 0.500 Drive Screw	4 Ea (4 ea)	121-Small Fab	
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	121-Small Fab	
RBW6205G00632-3G-77	Sticker	1 Ea (1 ea)	121-Small Fab	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBW6205G00632-3GP	1	0	0
121-Small Fab	90081A074	4	168	0
	RB41011	1	705	0
	RBW6205G00632-3G-77	1	4	0

[Dart Hawkesbury] Job Sheet - Lussier, Patrick

Specifications could not be found.

Plex 11/15/18 9:49 AM dart.Lussier.Patrick

		TITLE	
		TOOL, M/R BLADE LIFTING	
DRAWING NO.		REV. #	
RBW6205G00632-3G		6	
MATERIAL PCN PART QUANTITY DRAWN BY: CHECKED: DATE APPROV. APPR. NAME APPROVED:	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES DECIMALS AND FRACTIONS 2 TO 4 ANGLES 1/4 ROUNDED SURFACE FINISH 1. SURFACE ALL ARE EDGES 2. DIMENSIONAL LIMITS APPLY 3. DIMENSIONAL TOLERANCES PER ANSI Y14.5-1982		
	GILBERT CLOUGH ANDERSON LUNDSTAD GILBERT DATE: 02/21/2013 SHEET 1 OF 47		



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO041736



Supplier: MEM001-VC
Metac Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO041736

PO Date: 11/15/18

Due Date: 4/12/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Belanger, Natasha

Via: Ground

Pynt Terms: Net 60

Freight Terms:

Special Comments:

PO
COPY

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	186399	RBW6205G08031-3GP			Main Rotor Flanged Bushing Removal Tool REV 2	Received	-	4/12/19	1 Ea	1 Ea	0 Ea	\$1,012.00/Ea	\$0.00
Line Item Note: SIOP SUB ASSY OF TOP LEVEL RBW6205G06231-3G (ANNUAL USAGE 3)													
2	186400	RBW6205G08131-3GP			Main Rotor Flanged Bushing Install Tool REV 2	Received	-	4/12/19	1 Ea	1 Ea	0 Ea	\$1,103.00/Ea	\$0.00
Line Item Note: SIOP SUB ASSY OF TOP LEVEL RBW6205G06231-3G (ANNUAL USAGE 3)													
3	186401	RBW6205G05951-3GP			RBW6205G05951-3GP REV 2	Received	-	4/2/19	1 pcs	1 pcs	0 pcs	\$410.00/pcs	\$0.00
Line Item Note: SIOP (ANNUAL USAGE 3)													
4	186402	RBW6205G00632-3GP			Sling, Main Rotor Blade Lift As per Dwg RBW6205G00632-3G Rev. 6	Firmed	-	4/4/19 4/25/2019 APR 25 2019	1 pcs	0 pcs	1 pcs	\$5,980.00/pcs	\$5,980.00
Line Item Note: SIOP (ANNUAL USAGE 5)													
5	186395	RBW6405G08732-3GP			Tail Rotor Bushing Removal Tool RBW6405G08732-3G Rev. E	Received	-	4/12/19	1 Ea	1 Ea	0 Ea	\$770.00/Ea	\$0.00
Line Item Note: SIOP SUB ASSY FOR TOP LEVEL RBW6405G08632-3G (ANNUAL USAGE 3)													
6	186398	RBW6405G08832-3GP			Tail Rotor Bushing Install Tool As Per Dwg RBW6405G08832-3G Rev/ D	Received	-	4/12/19	1 Ea	1 Ea	0 Ea	\$796.00/Ea	\$0.00



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO041736



Items													
Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
Line Item Note SIOP SUB ASSY FOR TOP LEVEL RBW6405G08632-3G (ANNUAL USAGE 3)													
7	186417	RBW3205G00151-3GP			Main Landing Gear R&R Wrench REV 2	Received	-	4/2/19	1 pcs	1 pcs	0 pcs	\$400.00/pcs	\$0.00
Line Item Note SIOP (ANNUAL USAGE 2/3)													
8	186420	RBW6205G10451-3GP			Threaded Rod	Received	-	4/12/19	1 Ea	1 Ea	0 Ea	\$211.00/Ea	\$0.00
Line Item Note SIOP SUB ASSY FOR TOP LEVEL RBW6205G08931-3G (ANNUAL USAGE 4)													
9	186421	RBW6205G10551-3GP			Hammer	Received	-	4/2/19	1 Ea	1 Ea	0 Ea	\$211.00/Ea	\$0.00
Line Item Note SIOP SUB ASSY FOR TOP LEVEL RBW6205G08931-3G (ANNUAL USAGE 4)													
10	186423	RBW6205G10351-3GP			Guide rev 1	Received	-	4/2/19	1 Ea	1 Ea	0 Ea	\$211.00/Ea	\$0.00
Line Item Note SIOP SUB ASSY FOR TOP LEVEL RBW6205G08931-3G (ANNUAL USAGE 4)													
11	186425	RBW6205G10251-3GP			Threaded Rod	Received	-	4/2/19	1 Ea	1 Ea	0 Ea	\$211.00/Ea	\$0.00
Line Item Note SIOP SUB ASSY FOR TOP LEVEL RBW6205G08931-3G (ANNUAL USAGE 4)													
12	186428	RBW6205G10151-3GP			Pusher REV 1	Received	-	4/2/19	1 Ea	1 Ea	0 Ea	\$299.00/Ea	\$0.00
Line Item Note SIOP SUB ASSY FOR TOP LEVEL RBW6205G08931-3G (ANNUAL USAGE 4)													
13	186430	RBW6205G10651-3GP			Stop	Received	-	4/2/19	1 Ea	1 Ea	0 Ea	\$185.00/Ea	\$0.00
Line Item Note SIOP SUB ASSY FOR TOP LEVEL RBW6205G08931-3G (ANNUAL USAGE 4)													
14	186432	RBW1205G00831-3GP			Upper Deck Platform REV 5	Received	-	4/12/19	1 pcs	1 pcs	0 pcs	\$4,200.00/pcs	\$0.00
Line Item Note SIOP (ANNUAL USAGE 2)													
15	189050	RBW6205G11532-3GP			Swashplate Support Stand As Per Dwg RBW6205G11532-3G REV 5	Received	-	3/14/19	1 pcs	1 pcs	0 pcs	\$8,811.00/pcs	\$0.00
Line Item Note (ANNUAL USAGE 2/3)													
Grand Total:												\$5,980.00	

Packing List

Bill **Dart Aerospace Ltd.**
To: 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 Canada

Ship
To: 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 Canada

Shipment No: 25032
Shipment Date: 18-Apr-2019
Ship Via: Pick up at METEC
Order Number: 3184
Order Date: 01/17/19

Customer Code: DART
Phone: (613) 632-9577
PO Number: PO041736 R2
Terms: Net 60 Days

----- Quantity -----								
<u>Item</u>	<u>Open</u>	<u>Shipped</u>	<u>B/O</u>	<u>Canceled</u>	<u>Unit</u>	<u>Description</u>	<u>Revision</u>	<u>Job Number</u>
4	1	1	0	0	EA	DART-RBW6205G00632-3GP Sling, Main Rotor Blade Lift	6	3184-04

The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.

Received In Good Order By



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	Dwg Rev.#	P.O. Number
1	DART-RBW6205G00632- 3GP	Sling, Main Rotor Blade Lift	6	41736 R2

MATERIAL: supplied by METEC

We hereby certify that the above parts were made in conformance with applicable drawings.

DAS
40
8-20

METEC Metal Technology Inc.

George Theoret

Vankleek Hill, April 18, 2019



LOAD TEST PROTOCOL

Title : Sling, Main Rotor Blade Lift

DWG : RBW6205G00632-3G Rev : 6

Part # : _____ Serial # : _____

Date : April 10 /2019 Inspector : George Theoret

Inspection Method : Load Tester

As per Client Protocol: ☒ Protocol Attached : ☐

Load Requirement : 300 lbs. lbs ☒ kg _____

Load Weight for 5 minutes

Pre Inspection Deflection ☐ Distortion ☐ Cracking ☐ Tearing ☐ Others ☐

Description: _____

Under Load Inspection Deflection ☐ Distortion ☐ Cracking ☐ Tearing ☐ Others ☐

Description: _____
